



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2580-1
Job Sheet 198379


Part No: D2580-1		Job Qty: 6 pcs
Part Name: 205 Bent Tube		
		
Part Weight: 0 lbs	Status: New	Priority: Medium
Job Created: 7/25/19	Job Tracking No:	
Due Date: 8/5/19	Created By: Marie Lajeunesse	
Type: SOLD	Description:	
Note: DWG D2580 REV h SHEETS 1,2,3,8 IPP B 01.11.08 Revised Step 9, 10, 12, and 13 SM IPP Rev:C 10.12.01 as per DEO D1 DD ver:ec		
Ship Via:		

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Skidtubes - 1	6 pcs	8/5/19		0.00	5.56	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4	TF	
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
101	QC 5	6 pcs	8/5/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18	BE	
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
110	Handfinish - 1-1 Chemical-B4B	6 pcs	8/5/19		0.00	2.50	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		
							Handfinish - 1 - 4 - B4B		



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CANADA
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Container No: S209381



Part: D2580-1
Job No: 198379
Serial No/Batch: S209381
Revision: H
Inspector:
Exp Date:
Instructions: Various STC's

Date: 08/27/19

					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	✓ 19-08-28
120 QC 7	6 pcs	8/5/19	0.00 0.00		QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	MLG
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
125 Skidtubes - 2 - B4B	6 pcs	8/5/19	0.00 5.56		Skidtubes - 1 - B4B	
					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	
					Skidtubes - 4 - B4B	TF
					Skidtubes - 5 - B4B	
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
130 QC 5	6 pcs	8/5/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	BE

				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
140 Packaging 3-1 - Stock - B4B	6 pcs	8/5/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	TF
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150 QC 21 - SA	6 pcs	8/5/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	21
				QC 21 - SA - 53	21

Part Op 100 - (Skidtube) 1- Inspect mat'l D2500-1-190 for damage. 2-Drill pilot holes using drill jig DT 8149 A-BC-D 3-Open holes

Descriptions: to 0.508" as per Dwg D2580 4-Deburr holes per QSI002 section 4.2.3 and blow out all chips from inside of tube 5- Test fit inspection saddles on FWD & AFT saddle holes using DT9916.

101 - (QC5- Inspect part completeness to step on W/O)

110 - (Chemical Conversion Coat per QSI005 4.1)

120 - (QC7-Inspect Chemical Conversion Coat)

DATE

21

AUG 29 2019

125 - (Skidtube) 1- Bond web in place per QSI 015. A/R Sikaflex-291 batch: S200625 Sikaflex expire date: 07/25/2020 Start time and date: 3:41pm Aug 28/2019 bond for 12hrs
130 - (QC5- Inspect part completeness to step on W/O)
140 - (Identify as per dwg & Stock Location: _____) LOCATION : LG002
150 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2500-1-190	Ext'n -I' Beam Tube 4"	6 pcs (1 ea)	100-Skidtubes - 1	<u>S/68371</u>
D2596	Web, 205 Skidtube	6 pcs (1 ea)	125-Skidtubes - 2 - B4B	<u>S/9961 x6</u>
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Skidtubes - 1	D2500-1-190	6	73	0
125-Skidtubes - 2 - B4B	D2596	6	12	0
Part Specifications				
Specifications could not be found.				

Plex 7/25/19 12:56 PM Dart.lajeunesse.marie

ITEM	QTY -041	QTY -045	QTY -047	QTY -049	PART NUMBER	DESCRIPTION
1	X				D2880-041	SKIDTUBE ASSEMBLY
2		X			D2880-046	SKIDTUBE ASSEMBLY
3			X		D2880-047	SKIDTUBE ASSEMBLY
4				X	D2880-049	SKIDTUBE ASSEMBLY
20	1	1	1	1	D2880-1-180	EXTRUSION
21			18	18	D2870	BUSHING
22	1	1	1	1	D2878-9	STEP
23	4				D2878	SPACER
24	18	18	6	8	D2884-1	PLUG
25	18	18	6	8	D2884-3	O-RING
26	1	1	1	1	D2888	205 WEB
27	1	1	1	1	D2885	AFT CAP
28	1	1			D2884-5	WEARSHOE
29	1	1			D2884-9	WEARSHOE
30	1	1			D2884-11	WEARSHOE
31	1	1			D2884-13	WEARSHOE
32	20	20	24	24	D4002-1	SPACER
33			1		D4002-041	WEARPLATE ASSEMBLY
34			1		D4002-043	WEARPLATE ASSEMBLY
35				1	D2881-4	PHD WEARPLATE
36				1	D2881-3	AFT WEARPLATE
50	50	50			ALS7-1032-130 or M27-1032-130 or M294-1032-130 or ALS-1032-130	INSERT
61	50	50			AN2CA	BOLT
62	2	2	2	2	AN2-5A	BOLT
63			8	8	ANL-5A	BOLT
64	50	50			NAS1148C032R	WASHER (NAB0C010L)
65	2	2	2	2	NAS1148C032J	WASHER (NAB0C010L)
66			8	8	M27102-4	NUT (CT M27102L4)

GENERAL NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2884 WEBS
POWDER COAT (-041-047-049) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
POWDER COAT (-046) GREEN SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
BLACK ANTI-SPID PAINT AS INDICATED PER DART QSI 005 4.4.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2880-041 = 33.7 lbs
D2880-045 = 33.7 lbs
D2880-047 = 45.1 lbs
D2880-049 = 32.0 lbs
- 8) WELDING PER DART QSI 004.
- 9) INSERT D2880 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO
OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 018 BEFORE
BENDING. ENSURE HOLES LINE-UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND
ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS
ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DTR217 & DTR607 ONLY FOR D2880-041-045 TO LOCATE AND DRILL
Ø0.307 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTIONS B-4 AND F-F (60
PLACES) AFTER FINISH. INSTALL AN2CA BOLTS AND NAS1148C032R WASHERS WITH
SIKAFLEX-241-251.
- 12) INSERT D2884-1 PLUG C/W D2884-3 O-RING IN HOLES MARKED "P" (BOTH SIDES OF TUBE) AFTER
FINISH (18 PLACES FOR D2880-041-045 AND 8 PLACES FOR D2880-047-049)
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2886 AFT CAP TO PREVENT INTERFERENCE WITH
THE SPACER AT THIS LOCATION

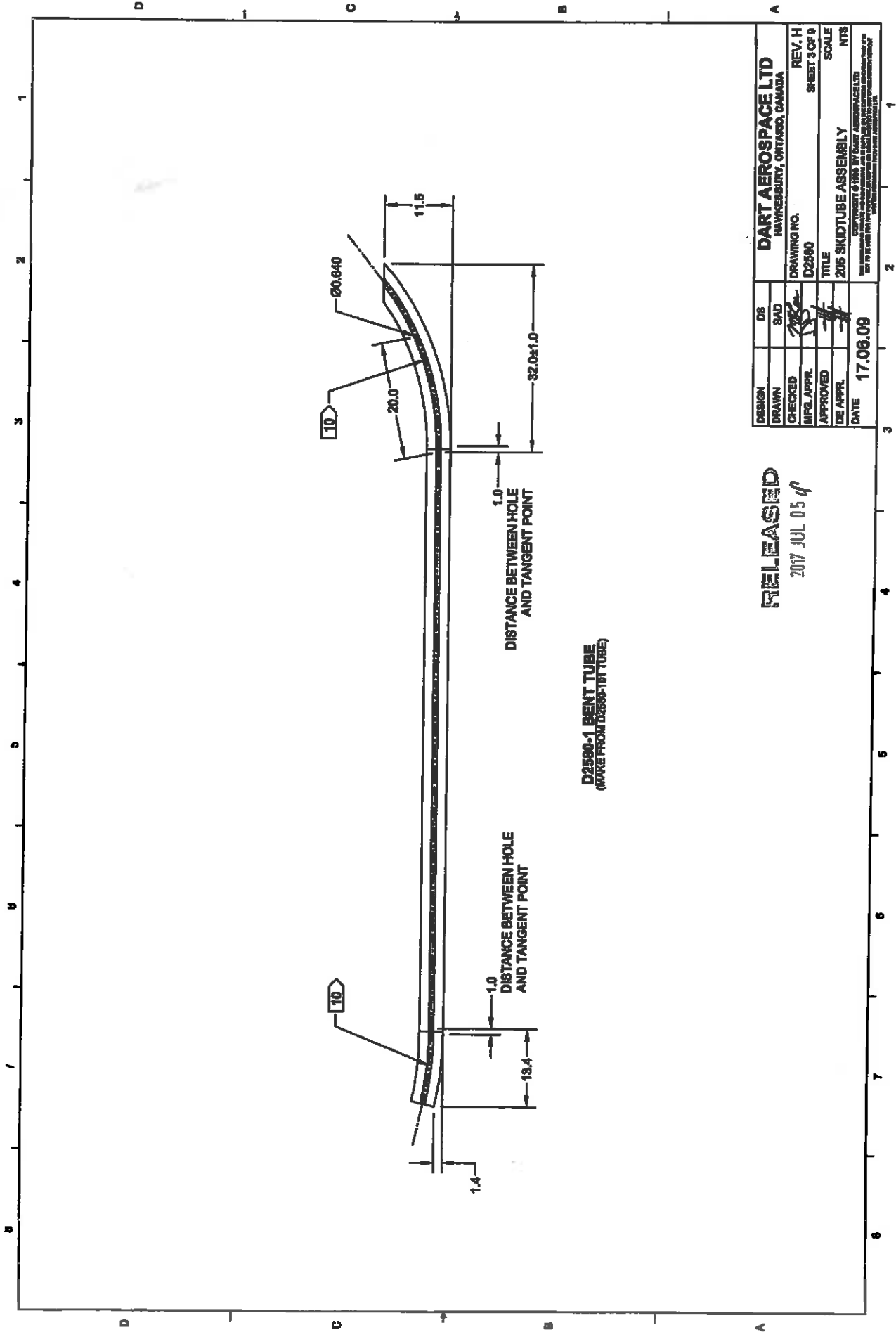
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19-07-25

RELEASED
2017 JUL 05
2007-shg

H	SHEET : PL DELETE D2886-145-13 GASKETS, WEIGHTS UPDATED ACCORDINGLY. SHEETS 2 & 4 PICTORIAL UPDATE FOR REMOVAL OF GASKETS.	SAD	17.06.08
G	ADDED -048 -047 WEIGHT. UPDATED PER DSI 0088	AJS	14.04.09
F	INCORPORATE DSD D2880-E-1 PER PART 2-218	DC	13.06.20
E	ADD D2880-047 (2N CH-7) AND D2880-7 (2N BS-0) INCLUDED DSD D2880-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DTR217 & DTR607 WAS TD2877-205 (2N CH-1)	RF	11.08.21
D	CHANGE TO 68 WEARPLATES AND GASKETS, INCLUDE DSD 5124/ 5183	PH	07.04.05
C	REDRAWN. INCLUDED DSD 8004/ 8097	CP	06.08.28
B	AS MANUFACTURED	DS	06.12.02
A	NEW ISSUE	DS	06.06.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	SAD		
CHECKED	RF		
APPR. APPR.	13	DRAWING NO.	D2880
APPROVED	RF	TITLE	205 SKIDTUBE ASSEMBLY
DE APPR.	RF	SCALE	NTS
DATE	17.06.08		

DART AEROSPACE LTD
HAMMERSBURT, ONTARIO, CANADA

REV. H
SHEET 1 OF 8

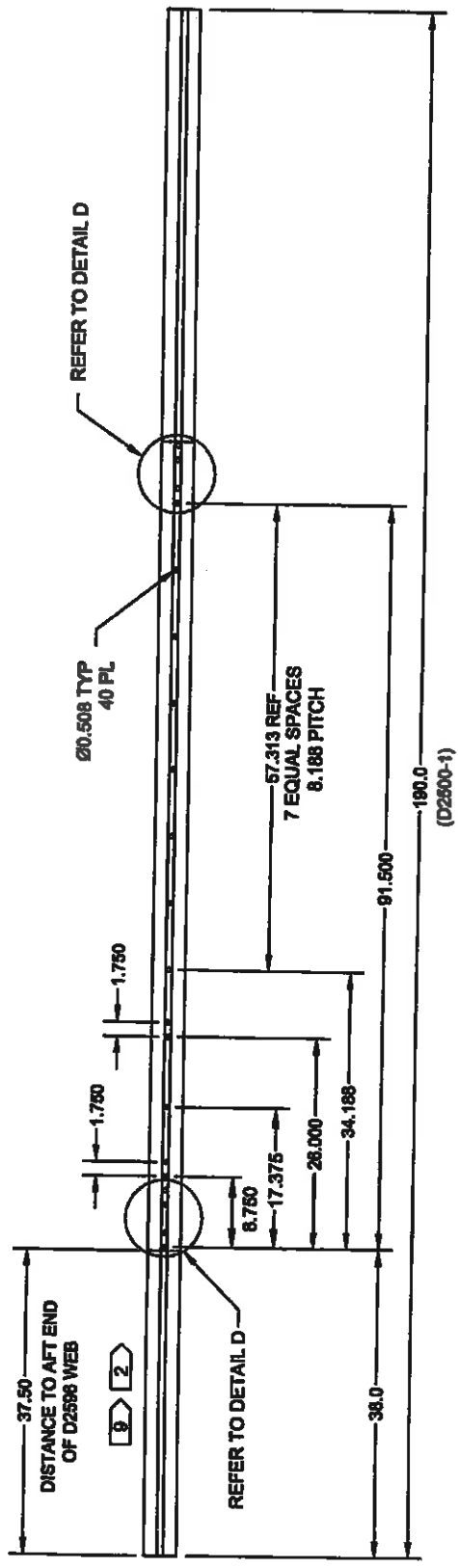


D2580-1 BENT TUBE
(WAKE FROM D2580-101 TUBE)

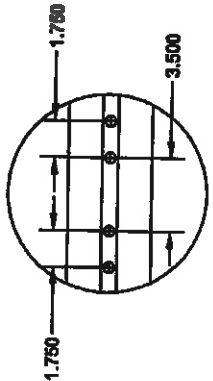
RELEASED
2017 JUL 05 q

DESIGN	DS	DART AEROSPACE LTD
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA
CHECKED	W	DRAWING NO.
MFG. APPR.	W	D2580
APPROVED	W	TITLE
DATE	17.06.09	2015 SKIDTUBE ASSEMBLY
		SCALE
		NTS

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D2580-101 TUBE



DETAIL D
SCALE 6X

RELEASED
2017 JUL 05

DESIGN	DS	DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA
DRAWN	SD	
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	17.06.09	
DRAWING NO.	D2580	REV. H SHEET 9 OF 9
TITLE	205 SKIDTUBE ASSEMBLY	SCALE NTS
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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



Route update only ☐

NCR No. _____

Job: _____ Part No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS042)			
Description Work Order Deviation		Disposition					
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
		Completed By					
		Lead hand / Supervisor					
		QC / QA Coordinator					